



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3200-1
Job Sheet 187858



Part No: D3200-1

Job Qty: 15 pcs

Part Name: Door Post Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/18

Job Tracking No:

Due Date: 12/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	15 pcs	12/31/18	12/31/18	0.00	0.14	Bandsaw - 1	
110	HAAS 4 Axis - B4B	15 pcs	12/31/18	12/31/18	0.07	4.93	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B	HAZIK GROD 12-12-21
130	QC 8	15 pcs	12/31/18	12/31/18	0.00	0.00	QC 8 - 12 QC 8 - 14 QC 8 - 17 QC 8 - 20 QC 8 - 25 QC 8 - 3 QC 8 - 32 QC 8 - 33 QC 8 - 35 QC 8 - 38 QC 8 - 39 QC 8 - 4 QC 8 - 44 QC 8 - 45 QC 8 - 49 QC 8 - 58 QC 8 - 8 QC 8 - 9 QC 8 - 68 QC 8 - 67	
140	Packaging 3-1 - Stock - B4B	15 pcs	12/31/18	12/31/18	0.00	0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B	DAS DEC 27 2018 68 9-89 DEC 27 2018



Container No: S140183



Part: D3200-1

Job No: 187858

Serial No/Batch: S140183

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/24/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
150	QC 21 - SA	15 pcs	12/31/18	0.000.00	QC 21 - SA - 21
					QC 21 - SA - 70

DAS
70
9-89
DEC 27 2018

Part Op 100 - (Bandsaw) Cut blank: 2.700" x 2.700
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3200-1 as per Folio FA337 and Dwg D3200
 130 - (QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.7500 sf (.05 ea)	100-Bandsaw - 1	504 5598

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MUHMWB10	1	80	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196		
2	Door Post Block	0.405inches ± 0.010	0.415 0.395		
3	Door Post Block	100Degrees ± 0	100 100		
4	Door Post Block	0.100inches ± 0.010	0.110 0.090		
5	Door Post Block	0.130inches ± 0.010	0.140 0.120		
6	Door Post Block	1.630inches ± 0.005	1.635 1.625		
7	Door Post Block	0.440inches ± 0.030	0.470 0.410		

Entered: _____ Date: _____



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8	Door Post Block	2.500inches $\pm$ 0.010	2.510 2.490
9	Door Post Block	1.845inches $\pm$ 0.010	1.855 1.835
10	Door Post Block	1.000inches $\pm$ 0.010	1.010 0.990
11	Door Post Block	1.620inches $\pm$ 0.050	1.670 1.570
12	Door Post Block	2.500inches $\pm$ 0.030	2.530 2.470
13	Door Post Block	0.750inches $\pm$ 0.030	0.780 0.720

Plex 12/18/18 8:12 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



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